

Date: Wednesday, 4/4/2007 8:53:13 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET PRELIM
Job Number	: 31581		
Estimate Number	: 12452		
P.O. Number	: N/A	Part Number	: D119756041
This Issue	: 4/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: IIN-D119-756 PG11-12
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30797	Drawing Revision	: B Rev. C
		Material	: JLM
Written By	:	Due Date	: 4/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev.A New Issue 06-06-14 JLM		
	: Est Rev. B 06.07.26 dwg revB, picklist EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

KS 07.05.04 (1)

2.0	31581A	BASKET LID ASS'Y (A119)
-----	--------	-------------------------



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

3.0	31581B	BASKET BASE ASS'Y (A119)
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Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Batch: B30543

5.0	D2258220	Placard
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch: B24871

6.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: B30547

7/10/1750

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Handle Weldment  
Batch: M30383

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spring  
Batch: B28363

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing  
Batch: B31107

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bumper  
Batch: B21139

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
placard  
Batch: B29576

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M101884

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M100327

7/5/18 scf

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M101771

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M101938

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102140

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M102929

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M103962

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M103641

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M103585

7/5/1884

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description:

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M103341

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cherry Rivets

Batch: M101518

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M102986

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M102552

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M5289

7/5/17 SQ

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

MF 07-05-18

QC5

INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP

SB 07/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Page 4

Comments

27.0

evD



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## Process Sheet

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description:

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
CLAMP KIT  
Batch: \_\_\_\_\_

30.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
CLEVIS  
batch: B30910 ✓

31.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
STRUT  
Batch: B29574 ✓

32.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
FWD ARM ASSEMBLY  
Batch: B29575 ✓

33.0

D35201

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
SPACER  
B 29578 ✓

34.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Bushing  
715/1750

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D26175

Spacer



1331756 ✓

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Spacer

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M103947 ✓

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
Batch: M104072 ✓

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
batch: M10895 ✓

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
batch: M102959 ✓

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)  
Washer  
Batch: M102929 ✓

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer

M103962 ✓

715/1750

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:13 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31581

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Washer

*M17619 ✓*

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Nut  
Batch: *M102552 ✓ 7/5/17 SP*

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C2071051180*

*7/5/18*

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D119  
Location: \_\_\_\_\_  
PPP Rev: *B*

*Pu 7/5/18 (1)*

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 7-25-18*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

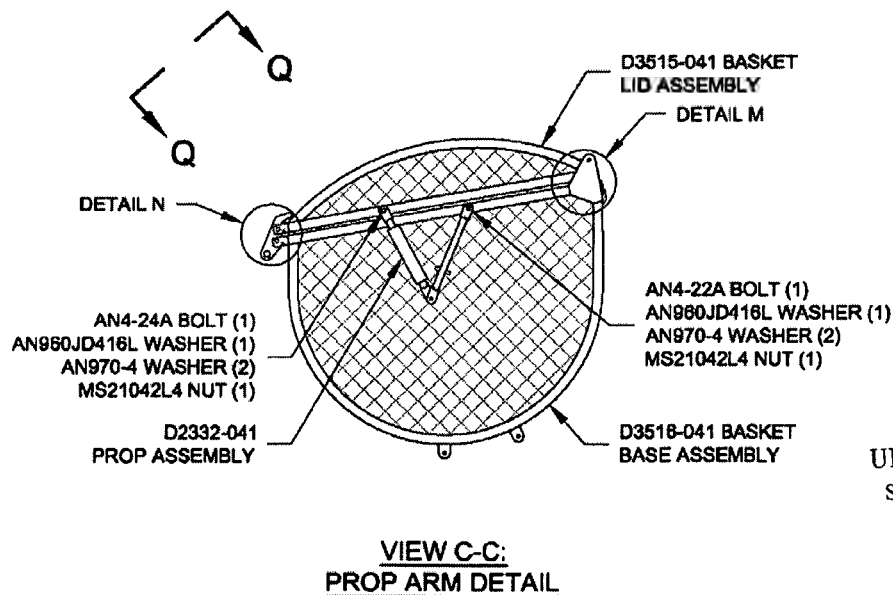
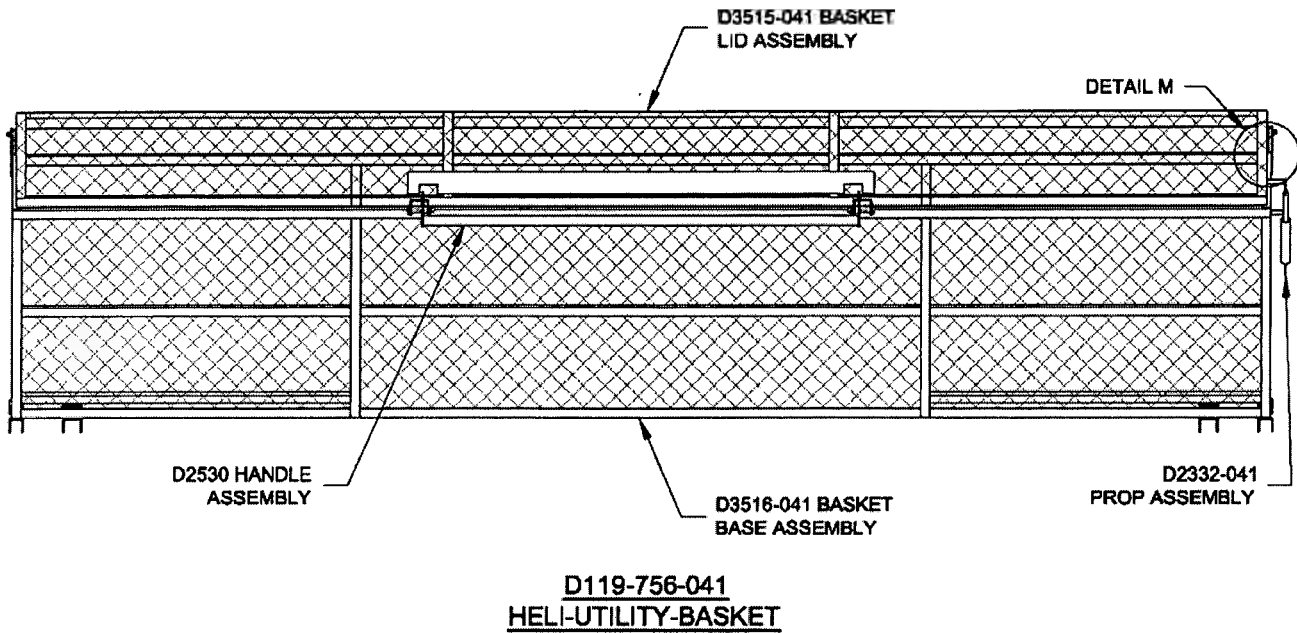
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#### 4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart **Heli-Utility-Basket™** which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



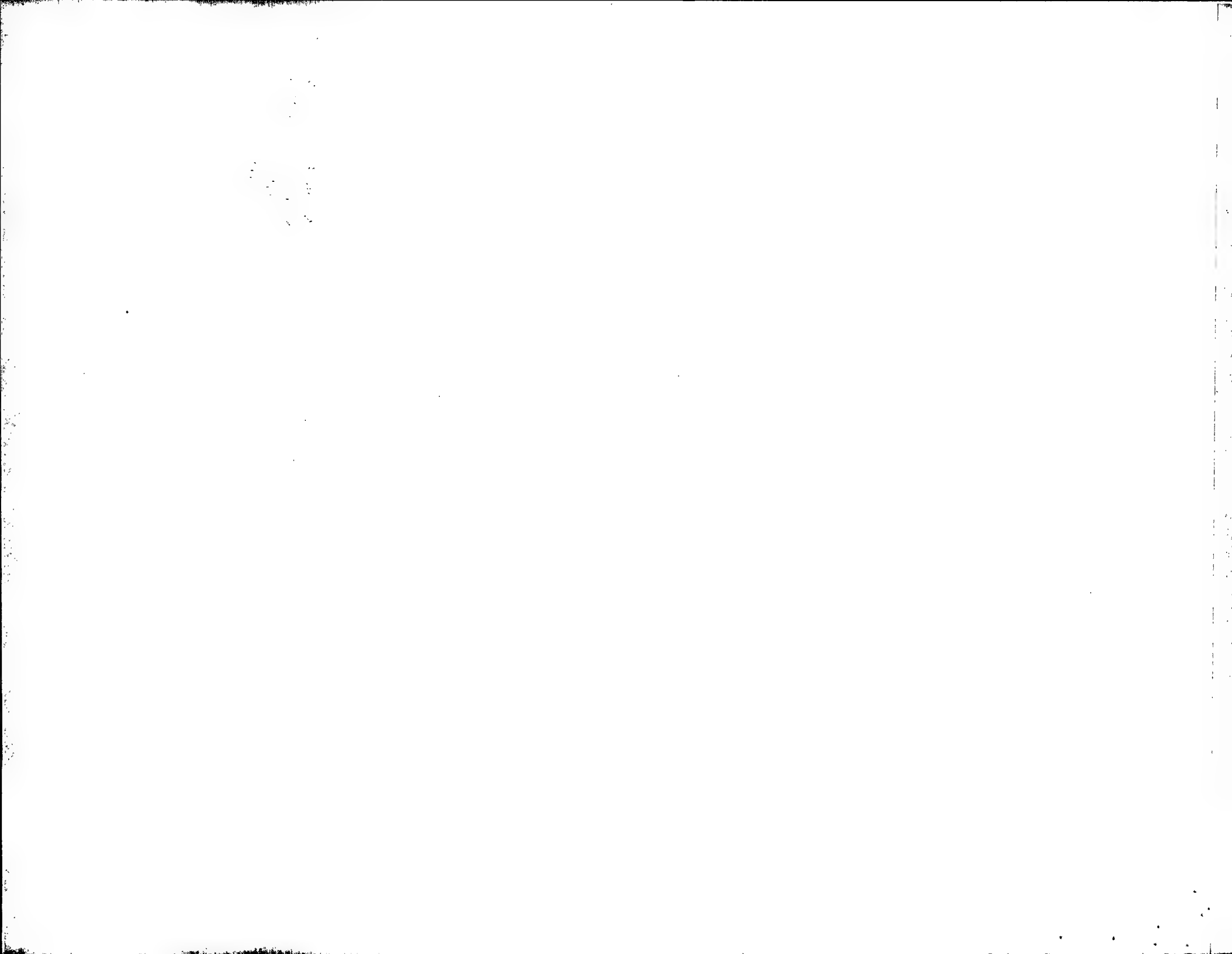
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

**Figure 4 – Basket Replacement Parts**  
(D119-756-041 Heli-Utility-Basket™)

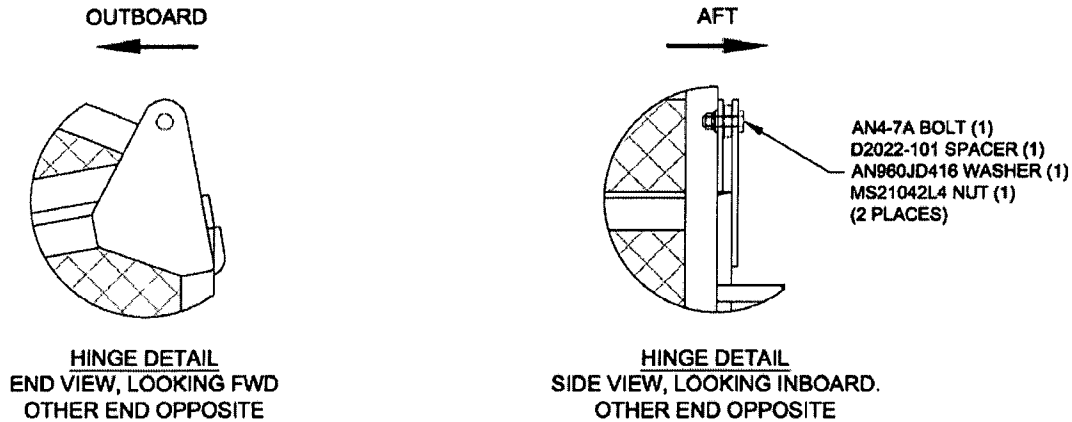
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Revision: **C**

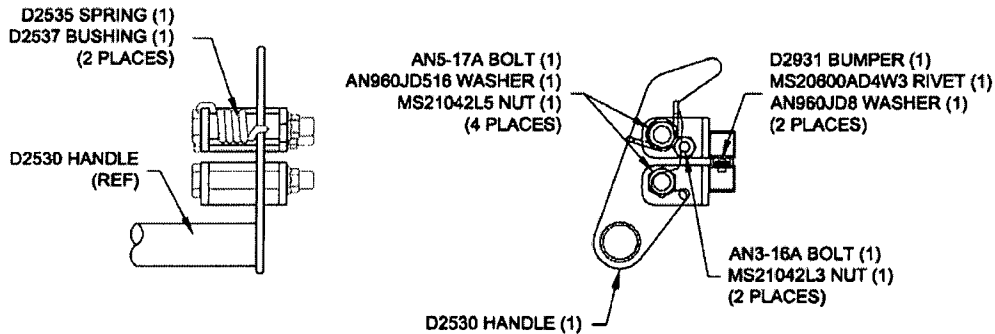
Date: 06.10.23







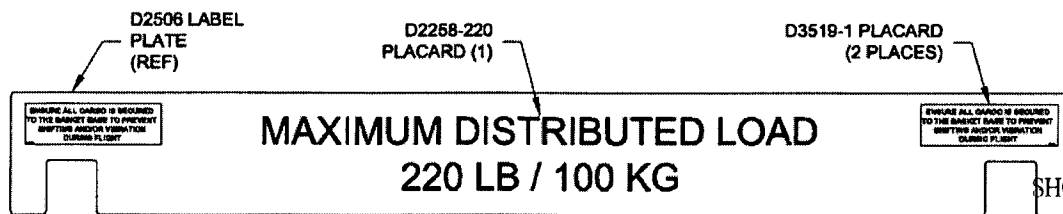
DETAIL M: HINGE



SPRING DETAIL

LATCH DETAIL

DETAIL N: HANDLE WELDMENT



VIEW Q-Q: PLACARDS  
ONLY PLACARDS AND  
LABEL PLATE SHOWN

**Figure 5 – Basket Replacement Parts & Placards**  
(D119-756-041 Heli-Utility-Basket™)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_



## 7.0 PARTS LIST

Qty-041	Qty-011	Qty-013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	* PLACARD
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
	2		D2856-200-766	ABRASION STRIP
2			D2931	* BUMPER
	1		D3041-1	CLAMP
	1		D3041-3	CLAMP
	1		D3041-5	CLAMP
	1		D3041-7	CLAMP
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1			AN4-22A	* BOLT
1			AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
2			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

\* indicates that part is pre-assembled on basket for customer

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

Date: Wednesday, 4/4/2007 8:53:27 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 31581A		
Estimate Number	: 12445		
P.O. Number	: N/A	Part Number	: D3515041
This Issue	: 4/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3515 PRELIMINARY Rev A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30797A	Drawing Revision	: PRELIMINARY A 307.01.09
	Type : LARGE FAB ASSY	Material	: N/A
Written By	:	Due Date	: 4/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: EST rev. A 06.06.05 Preliminary EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.	D22321	Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: 629535

PD 07-05-15 ①

20.	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: 63118

PD 07-05-09 ①

30	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: 628334

PD 07-05-15 ①

40.	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 627217

PD 07-05-15 ①

50	D2581	Mounting Bracket
----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: 630552

PD 07-05-15 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31581A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

60

M304TS0750W065

304 SQ Tube.75x.75x 065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M1043g1

RD 07-05-15 (1)

70

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 as per dwg D3516

2-Cut rib D3515-3 as per dwg D3516

3-Cut rib D3515-5 as per dwg D3516

4-Cut rib D3515-7 as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

RD 07-05-15 (1)

80

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

RD 07-05-15 (1)

90

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1203/05/15

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M104218

RD 07-05-17 (1)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

RD 07-05-17 (1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31581A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/18

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/18

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING / wing walk M103706  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

07/05/18  
07-05-18

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-05-18

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

07/05/18

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18

Job Completion



07/05/18



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

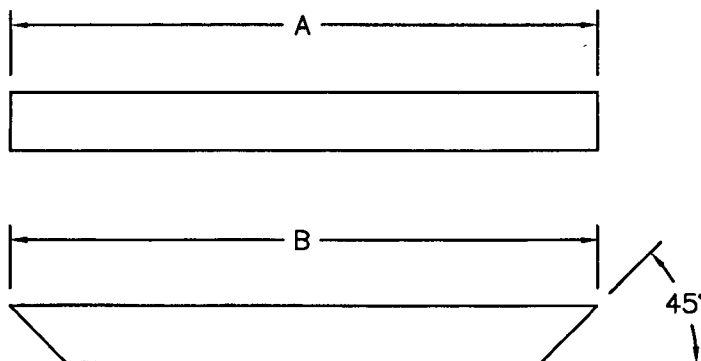
DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

**RELEASED**

06.11.17 H

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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WORK ORDER  
NO. \_\_\_\_\_

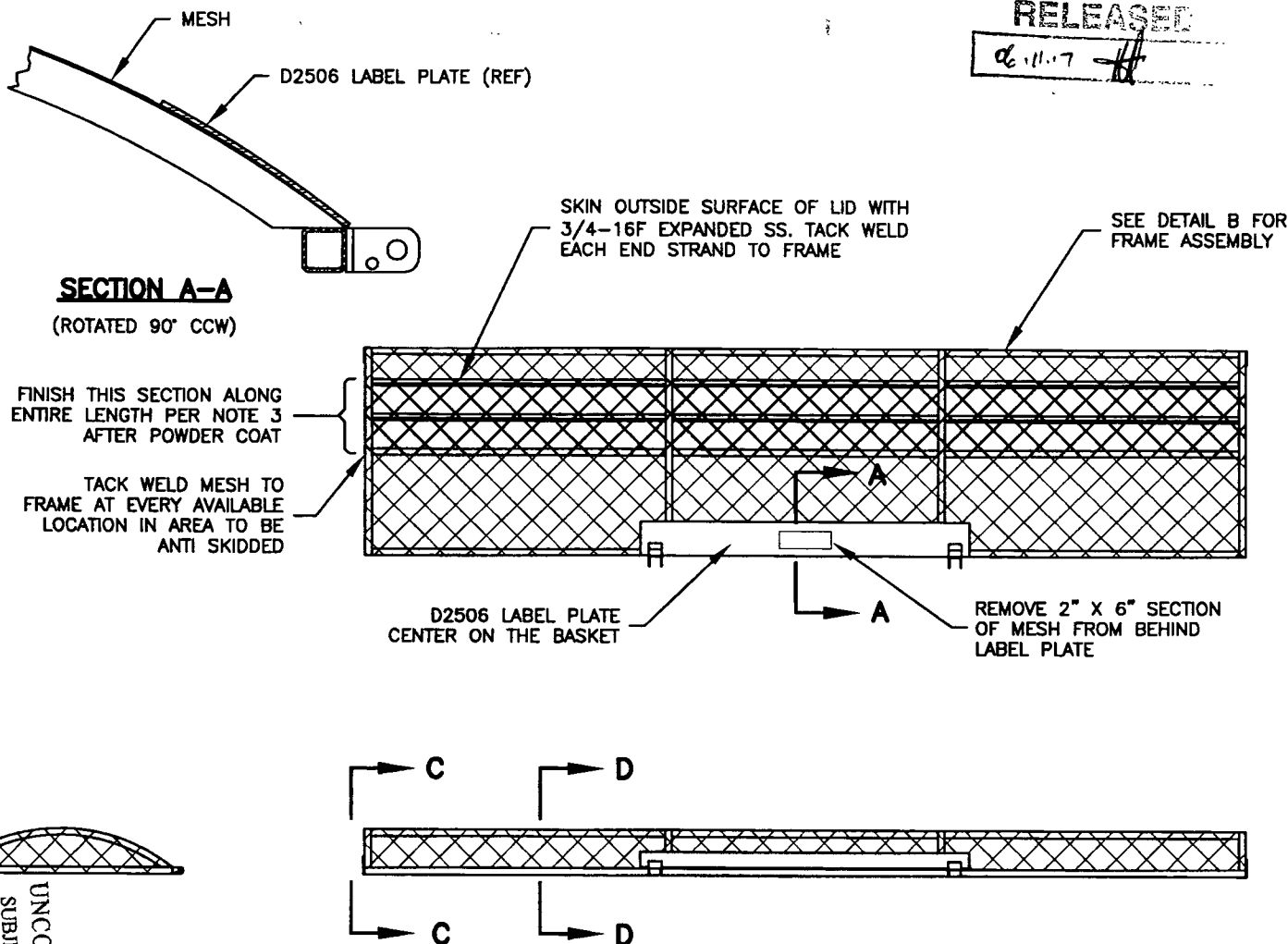
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**DART**

RELEASED

06.11.07



FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT

TACK WELD MESH TO  
FRAME AT EVERY AVAILABLE  
LOCATION IN AREA TO BE  
ANTI SKIDDED

D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

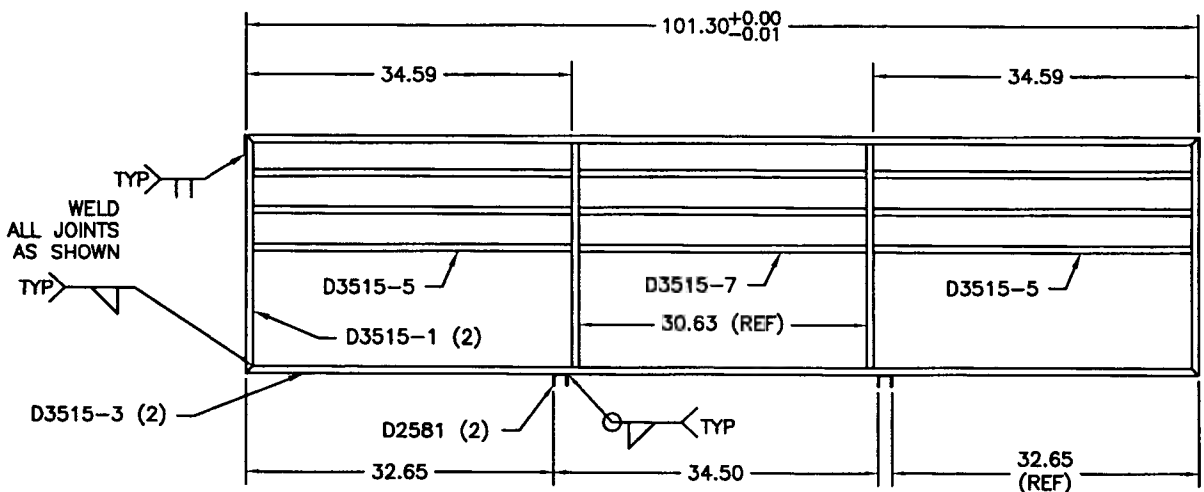
**D3515-041 BASKET LID ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

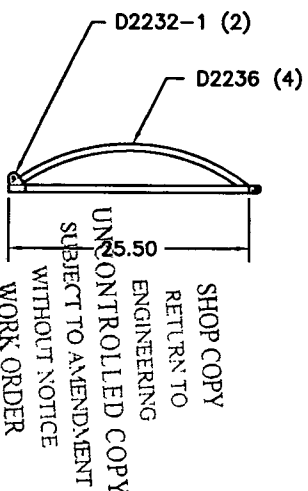
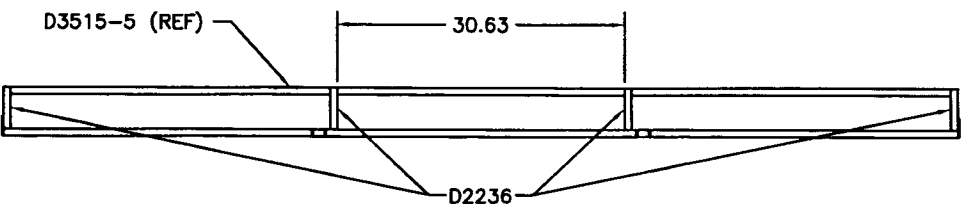
# DART

DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	BY	APPROVED	BY
DATE	06.05.05	TITLE	BASKET LID ASSEMBLY (A119)
SCALE	1:20	DRAWING NO.	D3515
REV. A	SHEET 3 OF 4		



## DETAIL B

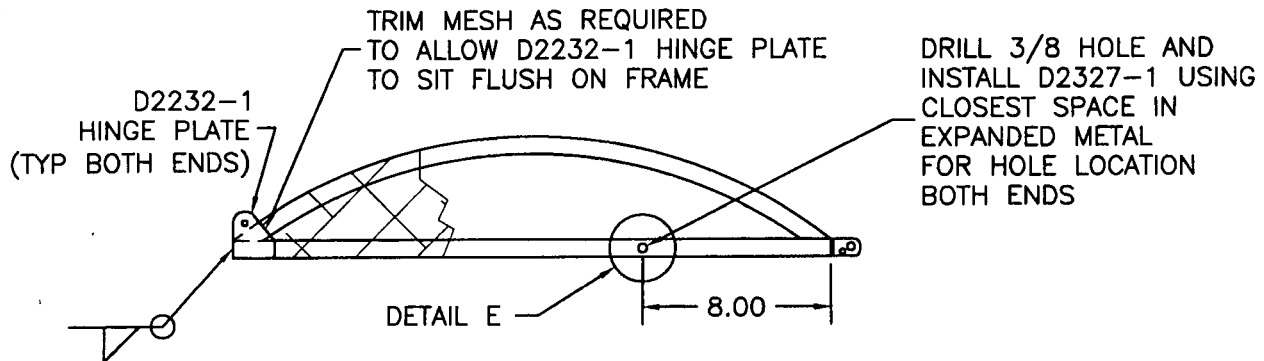
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



RELEASED  
06.11.17

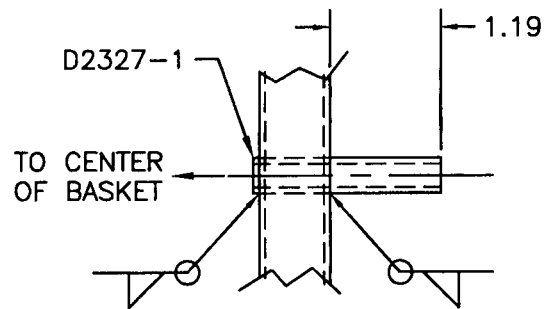


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

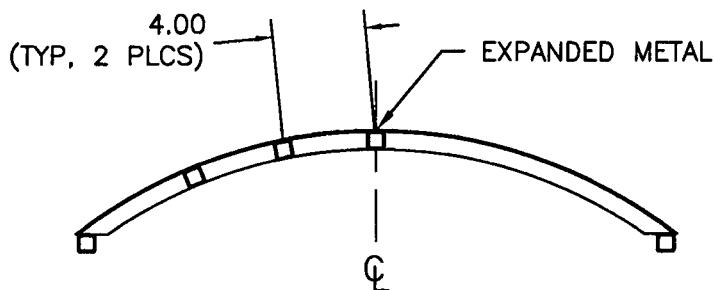


**SECTION C-C SIMILIAR BOTH END RIBS**

RELEASED  
06.11.17 H



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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WORK ORDER  
NO. \_\_\_\_\_

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Date: Wednesday, 4/4/2007 8:53:44 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASS'Y (A119)
Job Number	: 31581B		
Estimate Number	: 12431		
P.O. Number	: N/A	Part Number	: D3516041
This Issue	: 4/4/2007	S.O. No.	: N/A
Part Rev.	: NC	Drawing Number	: D3516 REV.B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30797B	Drawing Revision	: B
		Material	: N/A
Written By	: _____	Due Date	: 4/30/2007
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: EST rev. A 06.05.31 Preliminary EC EST rev. A 06.07.27 updated EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1-0	D34421	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Shim

Batch: B30564

PD 07-05-15 ①

2-0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mounting Bracket

Batch: B30552

PD 07-05-15 ①

3-0	D351611	CLEVIS
-----	---------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

CLEVIS

batch: B31800

PD 07-05-15 ①

4-0	D351613	CLEVIS
-----	---------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

CLEVIS

batch: B31627

PD 07-05-15 ①

5-0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer Bushing

Batch: B28597

PD 07-05-15 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31581B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6 0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B30873

PD 07-05-15 (1)

7 0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B31271

PD 07-05-15 (1)

8 0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M107307

PD 07-05-15 (1)

9 0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5-Cut rib D3516-9 from D3166-1 (4)

PD 07-05-15 (1)

10 0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 07-05-15 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/15/15 (1)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31581B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)  
Expanded Metal Flat Stainless steel  
Batch: M104218

07-05-17 ①

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut expanded metal for base as per dwg D3516  
  
2-Cut expanded metal for base ends as per dwg D3516  
  
3-Weld expanded metal to base as per dwg D3516

07-05-17 ①

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/17

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/17

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M103706

07-05-18 ①

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per Dwg  
Wing Walk: \_\_\_\_\_  
Black Spray Paint: \_\_\_\_\_

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ME 07-05-18.

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ED Date: 07/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:53:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31581B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8B 07/05/18 ①

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18

Job Completion



U 07/05/18

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

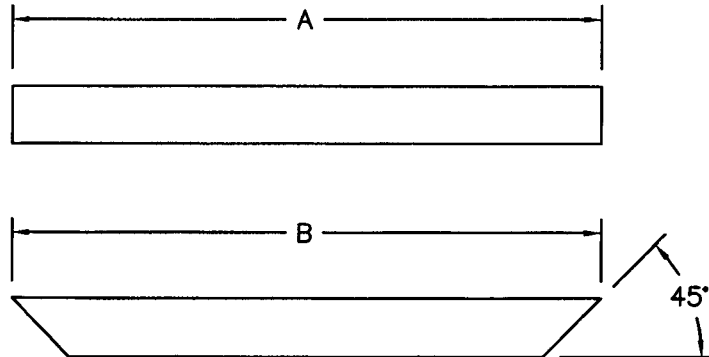
RELEASED

06.11.28

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

**PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS  
(REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

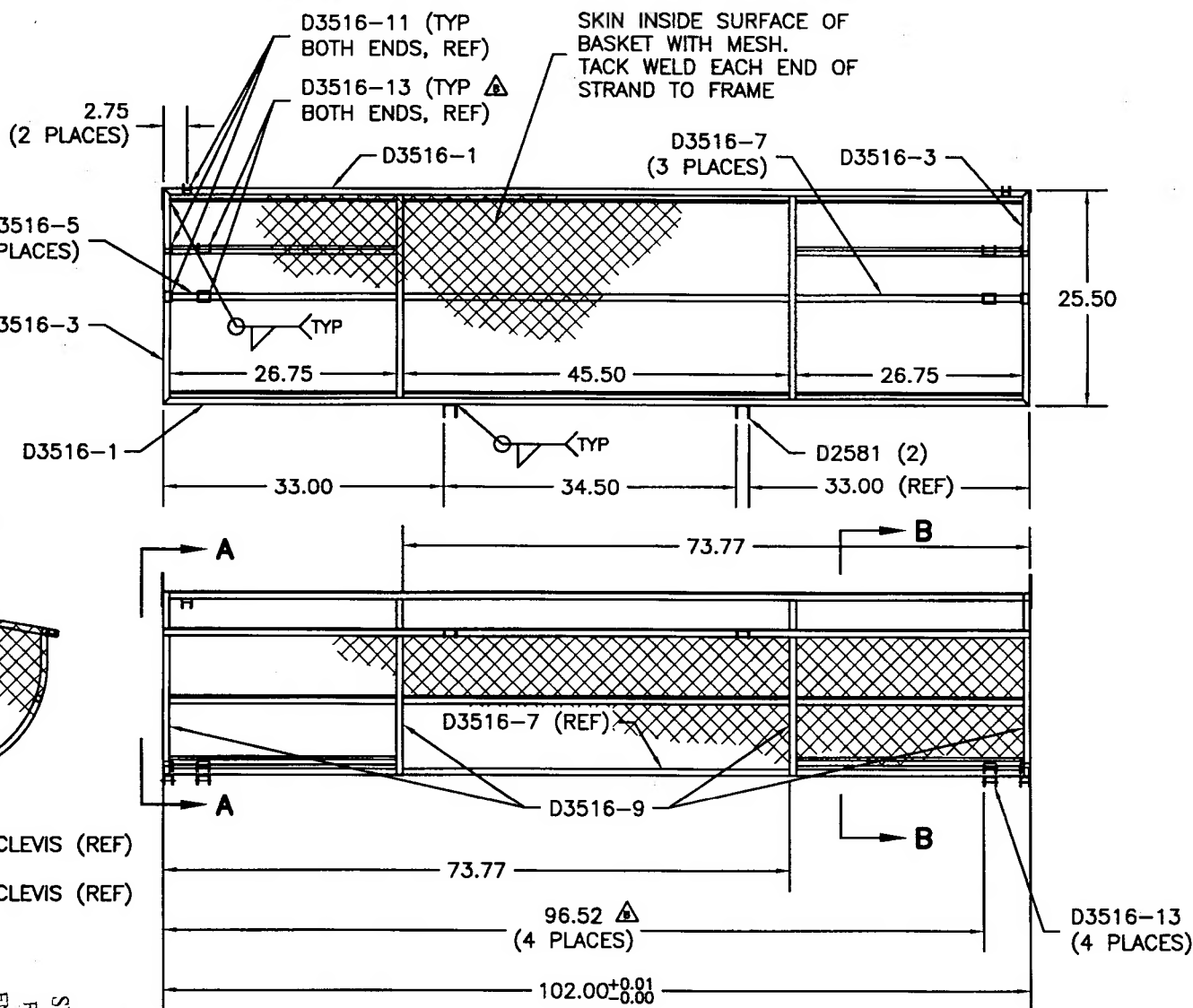
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	REV. B	SHEET 2 OF 5
06.07.25	D3516	SCALE	1:20
TITLE			
BASKET BASE ASSEMBLY (A119)			



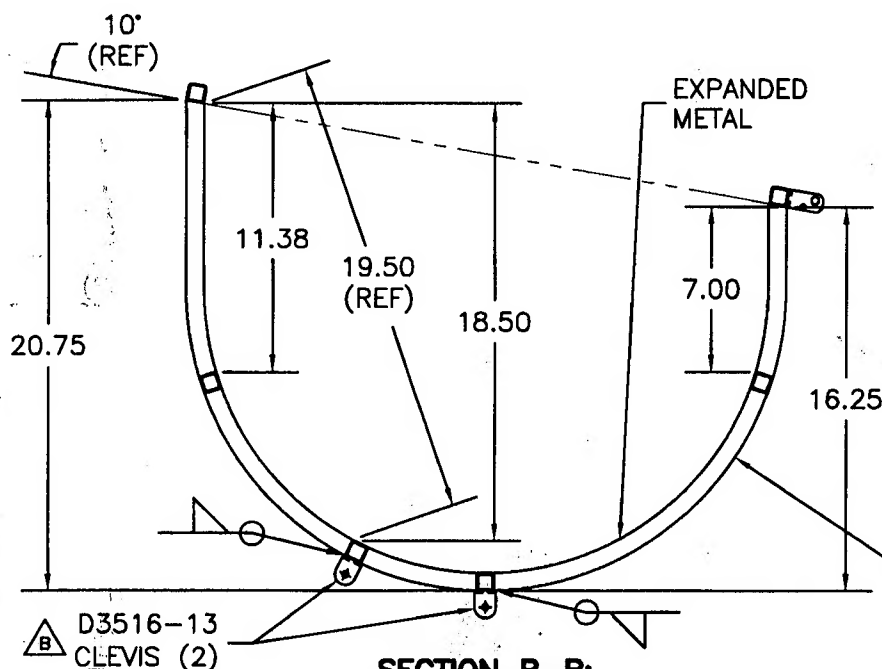
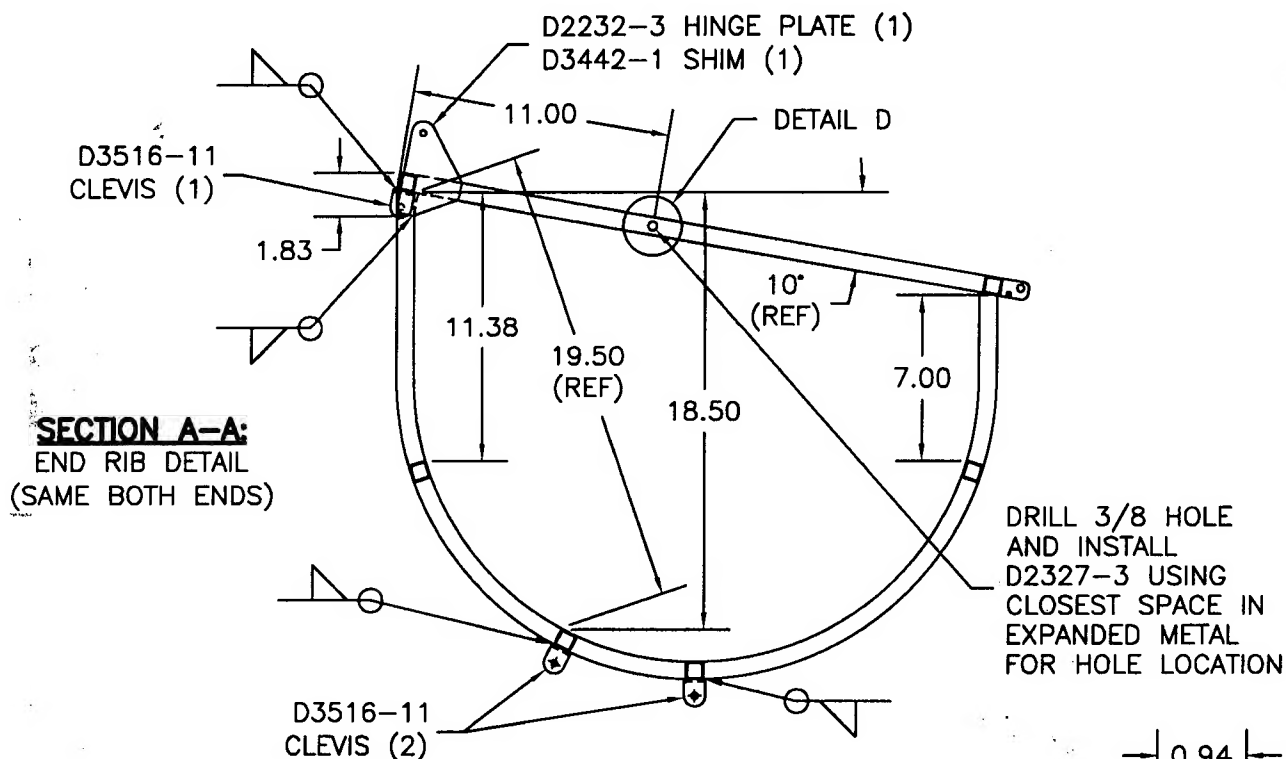
**D3516-041 BASKET BASE ASSEMBLY**

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06.11.28

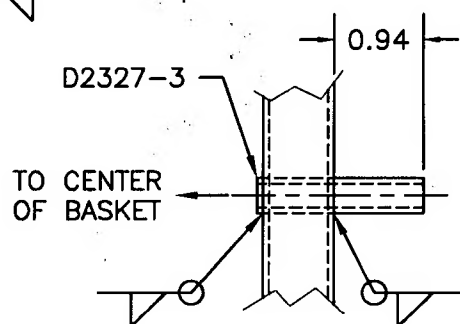
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 3 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8



**SECTION B-B:**  
CENTER RIB DETAIL  
(2 PLACES)

**RELEASED**06.11.28 *[Signature]*

D3516-9 RIB  
(MAKE FROM D2235-3)

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WORK ORDER  
NO. \_\_\_\_\_

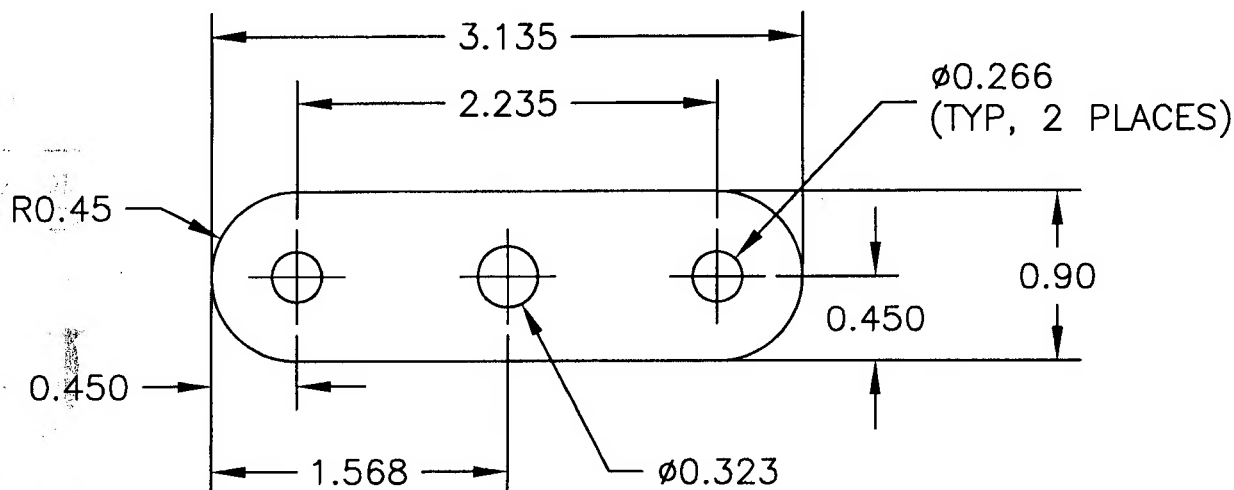
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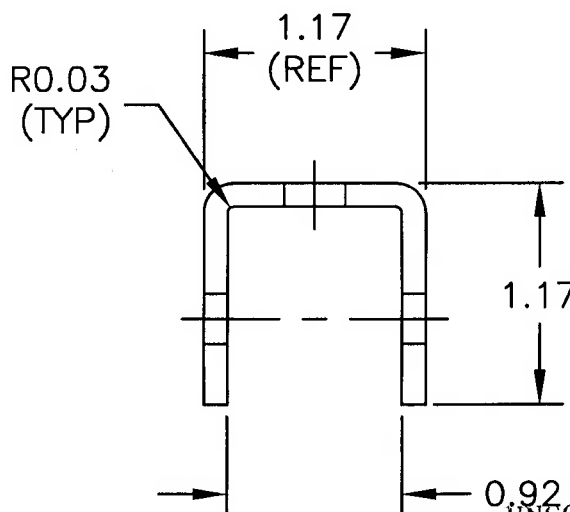
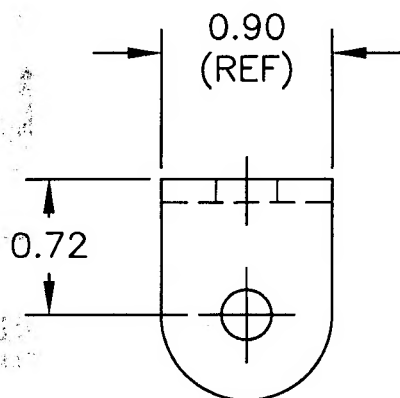
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 4 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



#### D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)

RELEASED  
06.11.28 *[Signature]*



#### D3516-11 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-11F  
2) ALL DIMENSIONS ARE IN INCHES  
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

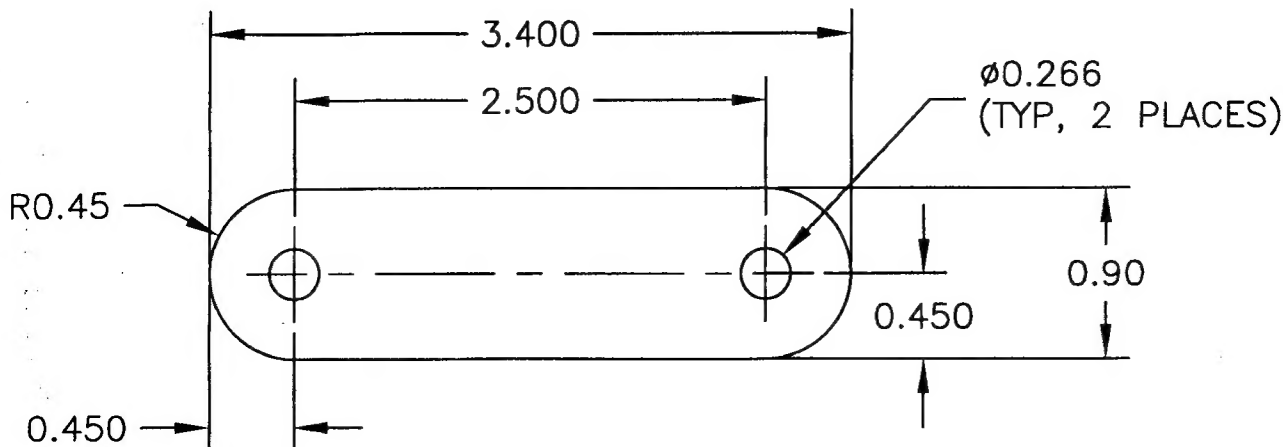
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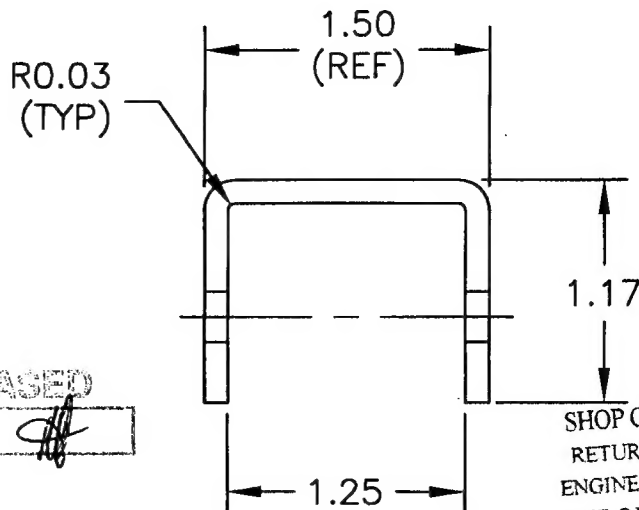
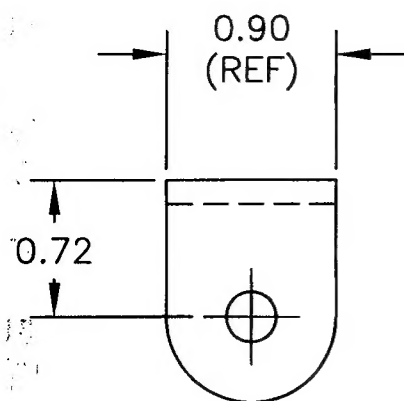


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3516	REV. B SHEET 5 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



#### D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)



RELEASED

Dec 11 28

#### D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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